

Date: Wednesday, 01/04/2009 9:08:38 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 46763  
 Estimate Number : 11029  
 P.O. Number :  
 This Issue : 01/04/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 46639  
 Written By :  
 Checked & Approved By : JUD 09.04.01  
 Comment : EST F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Drawing Name : BRACKET ASSEMBLY  
 Part Number : D2803041  
 Drawing Number : D2803 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 08/04/2009 Qty: 4 Um: Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D28031

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 STA 84 BRACKET

Pick:

Qty Part Number Description  
 1 D2803-1 Bracket

Batch

B44477 (34) B41738 (12)

*Ep 09/04/01*

2.0

D28051

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 STOP

Pick:

Qty Part Number Description Batch  
 1 D2805-1 Stop

Batch

B41081

*Ep 09/04/01*

3.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Bushing

Pick:

Qty Part Number Description Batch  
 1 D2809 Bushing

Batch

B46438

*Ep 09/04/01*

4.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Press D2805-1 into arm as per Dwg D2803

*Ep 09/04/01* (4)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 01/04/2009 9:08:38 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46763

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 021401 (K4)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M110939

START TIME: 13:30

OVEN TEMPERATURE: 500°

FINISH TIME: 14:00

BR 09-04-01

(H)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-01

CU

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

EP 09/04/02 (4)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M109147

EP 09/04/02

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M110562

EP 09/04/02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46763

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer

A/R LPS-3

Corrosion Spray

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

1109268

1109929

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 150

9/4/2

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-04-02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

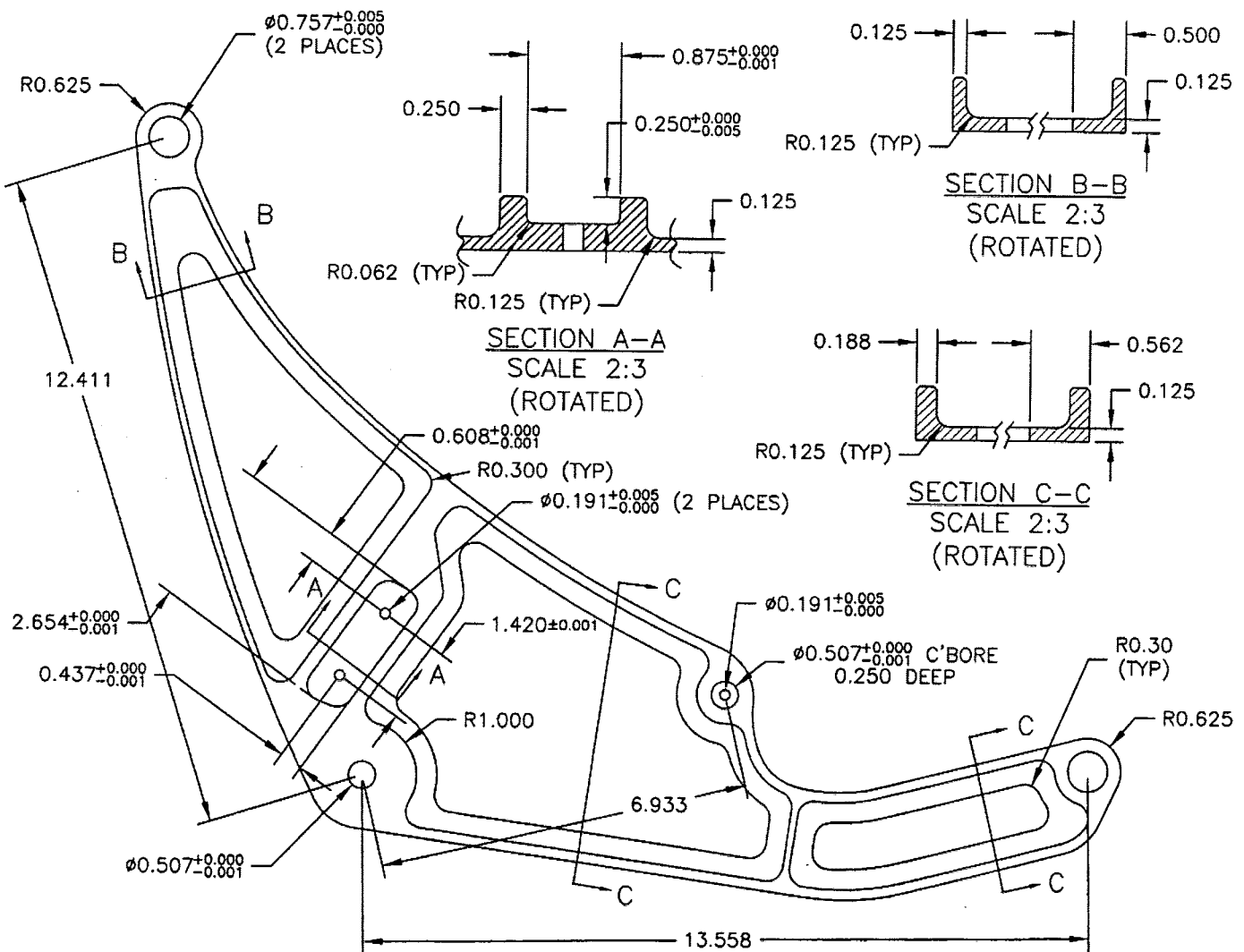
**NOTE:** Date & initial all entries



|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>CP                  | DRAWN BY<br>CP                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2803                              | REV. B<br>SHEET 1 OF 2 |
| DATE<br>04.11.22              | TITLE<br>STA 84 BRACKET        |   | SCALE<br>1:3           |
| A                             | 00.11.07                       | NEW ISSUE   |                        |
| B                             | 04.11.22                       | ADD CUTOUTS & -043/-044                           |                        |

RELEASED

05.03 11 *[Signature]*



**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. *46763*

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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

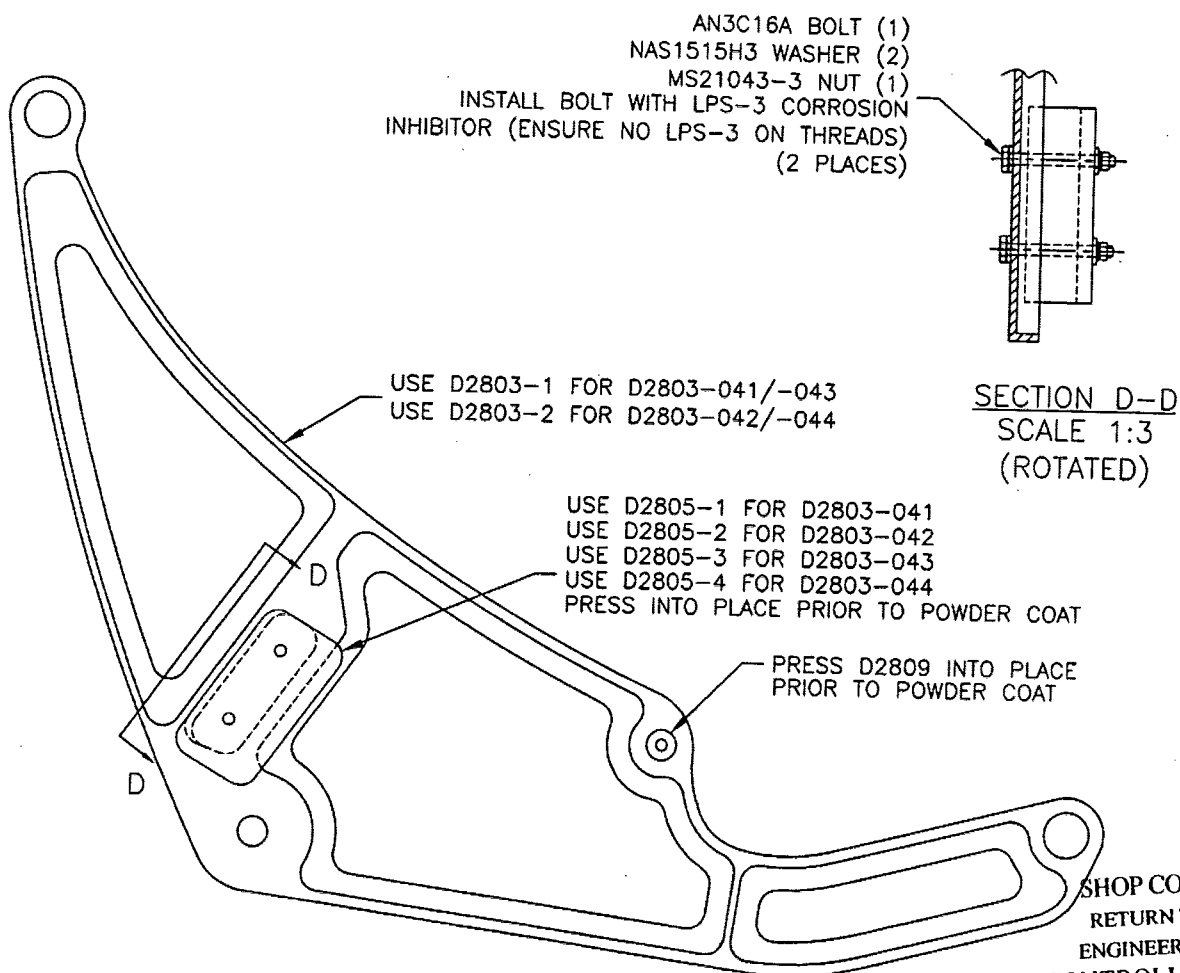
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>CP                  | DRAWN BY<br>CP                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2803                              | REV. B<br>SHEET 2 OF 2 |
| DATE<br>04.11.22              |                                | TITLE<br>STA 84 BRACKET                           | SCALE<br>1:3           |



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RELEASED 40763

05-03-11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries